

# Work Order ID 52935

October 19, 2009 11:02:26 AM



Page 1

Item ID: D3992-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Reinforcement

Start Date: 10/19/09 Start Qty: 4.00



Cust Item ID:

Required Date: 11/02/09 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

*RA*

Date: *09-10-19*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3992

A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3992

Dwg Rev: *A*

Prog Rev: *A*

2-Deburr if necessary

*HB 9-10-08*

*(S)*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

*HB 9-10-08*

# Work Order ID 52935



Page 2

October 19, 2009 11:02:26 AM

Item ID: D3992-1

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Start Date: 10/19/09 Start Qty: 4.00



Cust Item ID:

Required Date: 11/02/09 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

2) 802/10/28

(45) 0

Quality Control

130

Bend as per dwg

0.00



Brake NC

Memo

0.00

80 09/11/04

5 0

Brake NC

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

2) 802/10/28

(45) 0

Quality Control

# Work Order ID 52935

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Page 3

Item ID: D3992-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Reinforcement

Start Date: 10/19/09 Start Qty: 4.00



Cust Item ID:

Required Date: 11/02/09 Req'd Qty: 4.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00	09/11/10			X5	0		
160  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00	MD 09/11/10			X5			
170  Packaging Packaging	Identify as per dwg & Stock Location: _____  Memo	0.00 0.00	9/11/10					50	

# Work Order ID 52935

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Page 4

Item ID: D3992-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Reinforcement

Start Date: 10/19/09 Start Qty: 4.00



Cust Item ID:

Required Date: 11/02/09 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/11  
MF  
09-11-11

# Picklist Print

October 19, 2009 11:02:33 AM

Page 1

Work Order ID: 52935

Parent Item: D3992-1RevA-PRELIM

Parent Item Name: Reinforcement

Comments:

Start Date: 10/19/09

Required Date: 11/02/09

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased	No			100	sf	284.9347	0.3499	15		



6061-T6 .080 Sheet



189-10-28

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT

284.9347

107904

0.02

110254

2.5

110630

38.0926

112040

0.0437

112141

33

112512

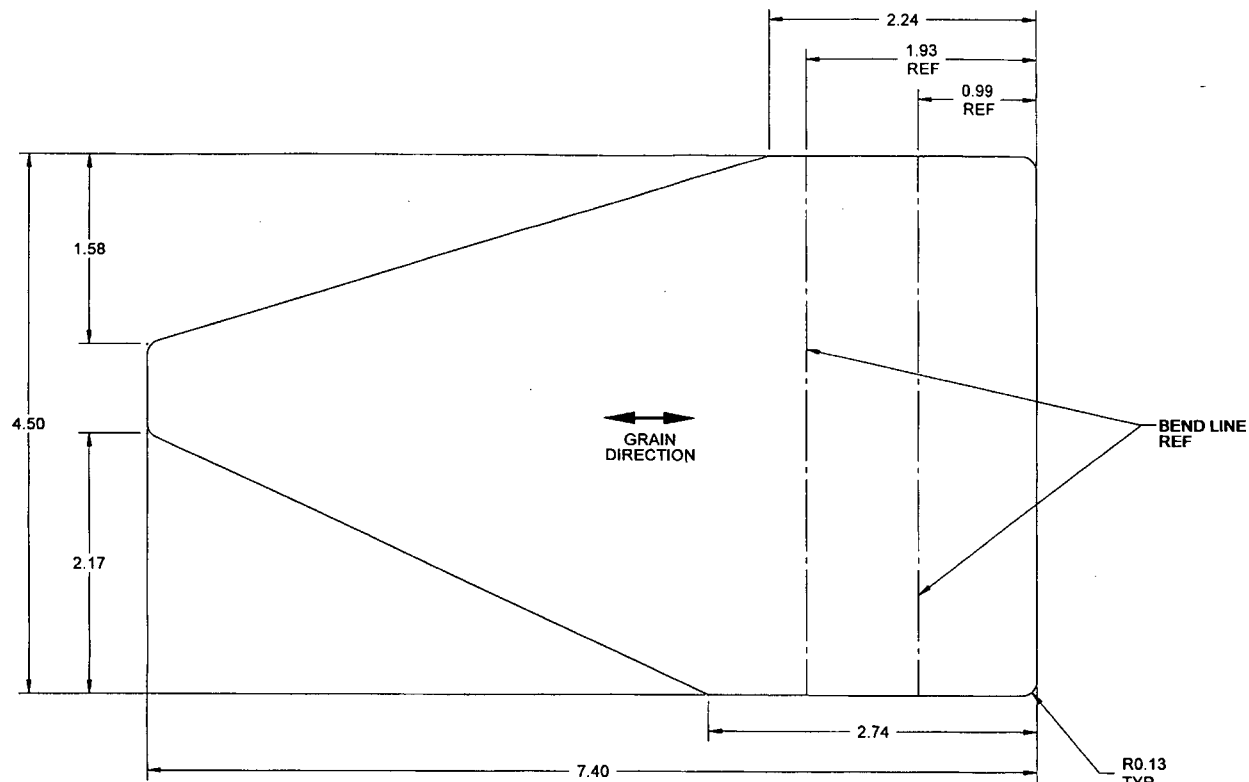
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112763

192

112763





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*RP 09/10-10*

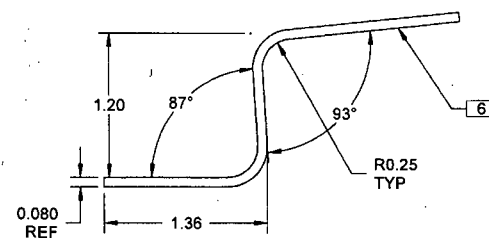
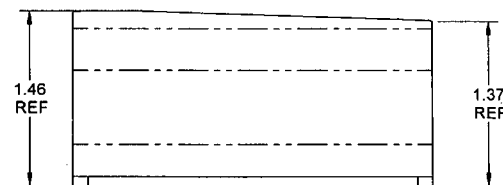
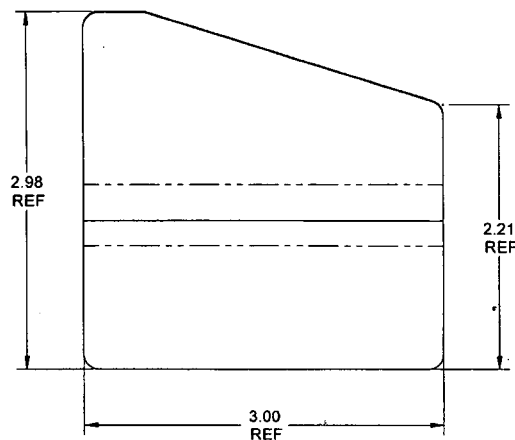
# **D3992-3F REINFORCEMENT FLAT PATTERN**

**RELEASED**  
2009-10-08  
*JWP*

## **NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
REF DART SPEC M6061T6S.080
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.07 lbs

DESIGN	<i>AS</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>AS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>ALS</i>	DRAWING NO. <b>D3992</b>	REV. A
MFG. APPR.	<i>AS</i>		SHEET 6 OF 6
APPROVED	<i>AS</i>	TITLE <b>REINFORCEMENT</b>	SCALE NTS
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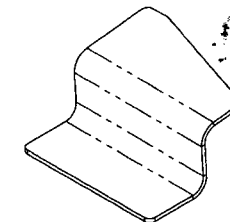


**D3992-1 REINFORCEMENT**  
MADE FROM D3992-1F

**NOTES:**

- 1) MATERIAL: MADE FROM D3992-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3992-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.03 lbs

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**RELEASE**  
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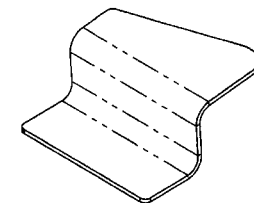
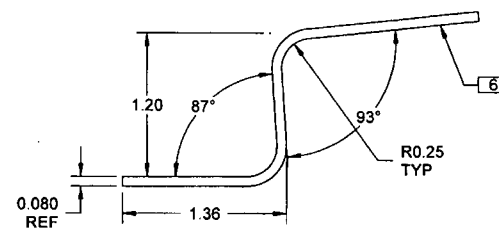
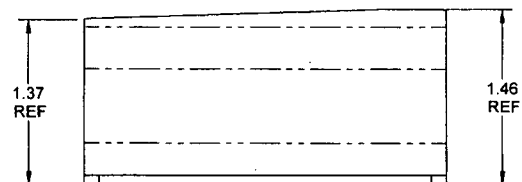
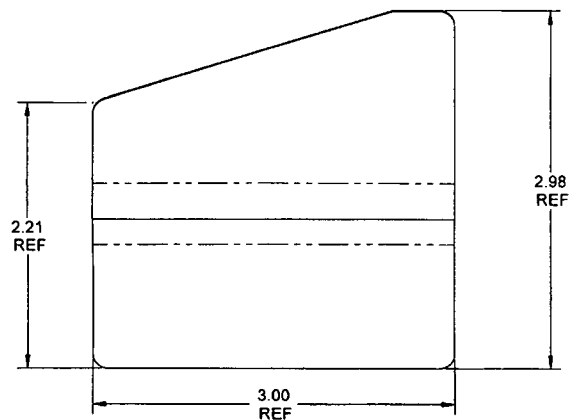
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A	NEW ISSUE		09.09.28
DESIGN			
DRAWN			
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MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.09.28		

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	REV. A
D3992	SHEET 1 OF 6
TITLE <b>REINFORCEMENT</b>	SCALE NTS

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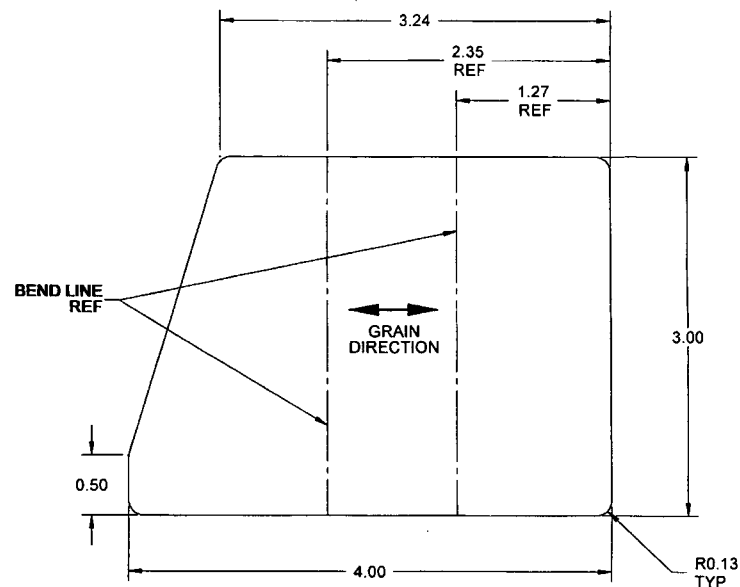
**D3992-2 REINFORCEMENT**  
MADE FROM D3992-1F

**RELEASED**  
2009-10-08

**NOTES:**

- 1) MATERIAL: MADE FROM D3992-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3992-2" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.03 lbs

DESIGN	<u>45</u>	<b>DART AEROSPACE LTD</b>	
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CHECKED	<u>AIS</u>	DRAWING NO.	REV. A
MFG. APPR.	<u>45</u>	D3992	SHEET 2 OF 6
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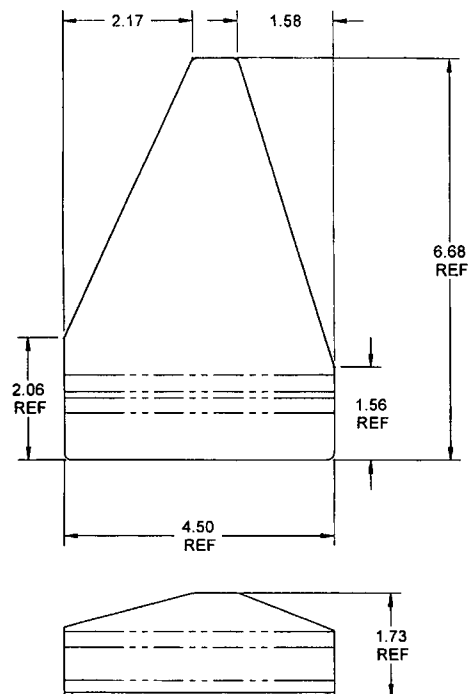
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JMP

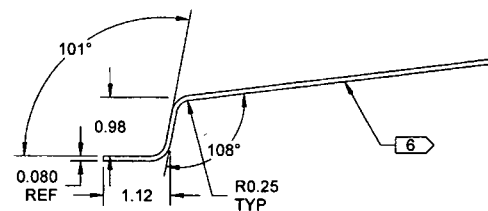
**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
REF DART SPEC M6061T6S.080
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs

DESIGN	<i>AS</i>	<b>DART AEROSPACE LTD</b>	
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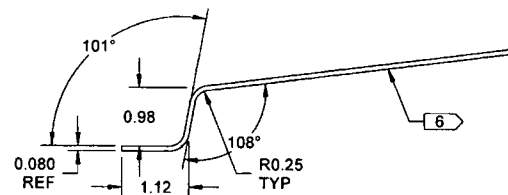
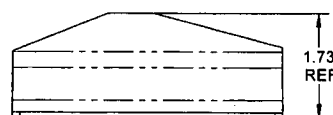
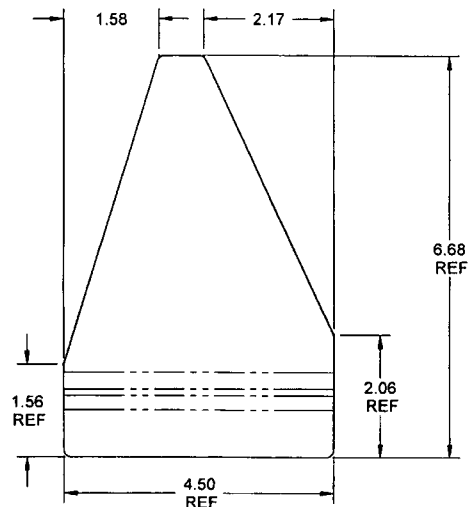
**D3992-3 REINFORCEMENT**  
MADE FROM D3992-3F

**RELEASED**  
2009-10-08

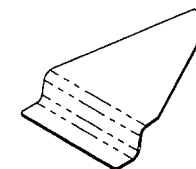
**NOTES:**

- 1) MATERIAL: MADE FROM D3992-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3992-3" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.07 lbs

DESIGN	<u>AS</u>	<b>DART AEROSPACE LTD</b>	
DRAWN	<u>AS</u>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<u>AS</u>	DRAWING NO. <b>D3992</b>	REV. A
MFG. APPR.	<u>AS</u>		SHEET 4 OF 6
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**D3992-4 REINFORCEMENT**  
MADE FROM D3992-3F



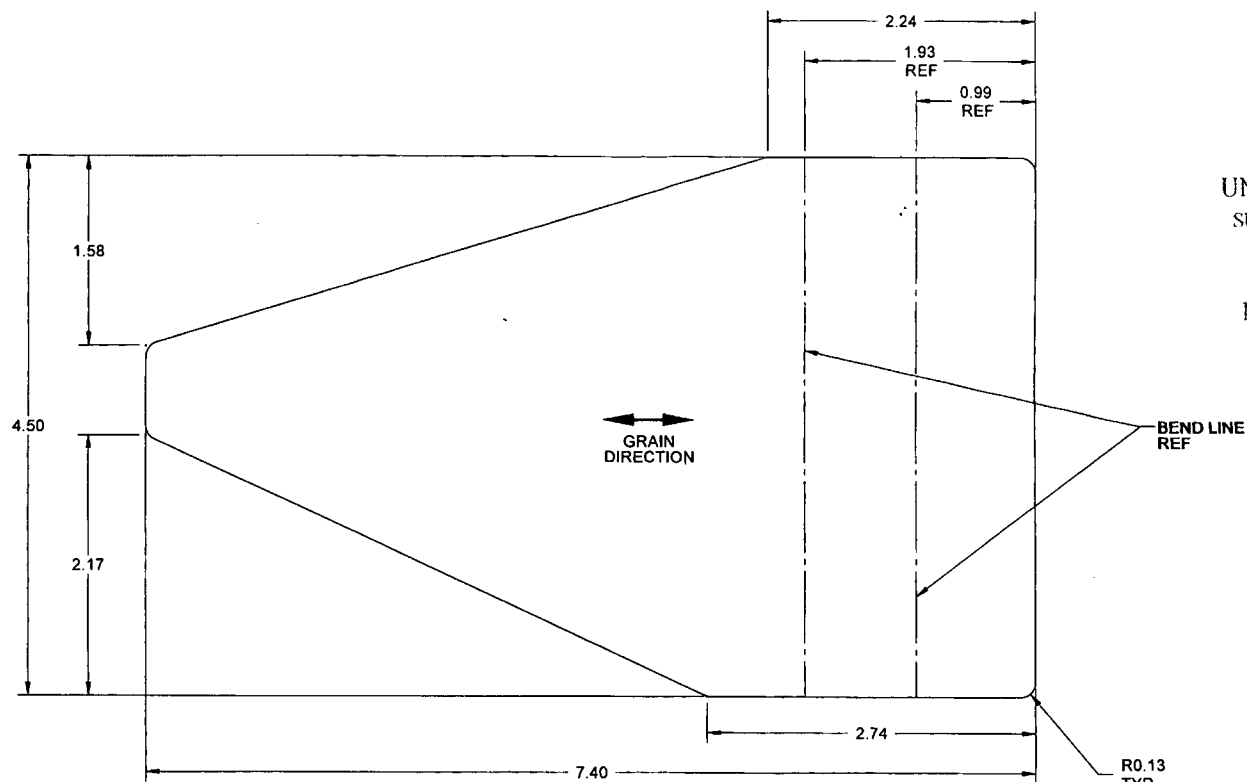
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2009-10-08  
JAP

**NOTES:**

- 1) MATERIAL: MADE FROM D3992-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3992-4" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.07 lbs

DESIGN	<u>AS</u>	<b>DART AEROSPACE LTD</b>	
DRAWN	<u>AS</u>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<u>AJS</u>	DRAWING NO.	REV. A
MFG. APPR.	<u>BE</u>	D3992	SHEET 5 OF 6
APPROVED	<u>AS</u>	TITLE	SCALE
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# **D3992-3F REINFORCEMENT FLAT PATTERN**

**RELEASED**  
2009-10-08  
JWP

## **NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
REF DART SPEC M6061T6S.080
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.07 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AJS</i>	DRAWING NO. <b>D3992</b>	REV. A
MFG. APPR.	<i>E</i>		SHEET 6 OF 6
APPROVED	<i>10</i>	TITLE <b>REINFORCEMENT</b>	SCALE NTS
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